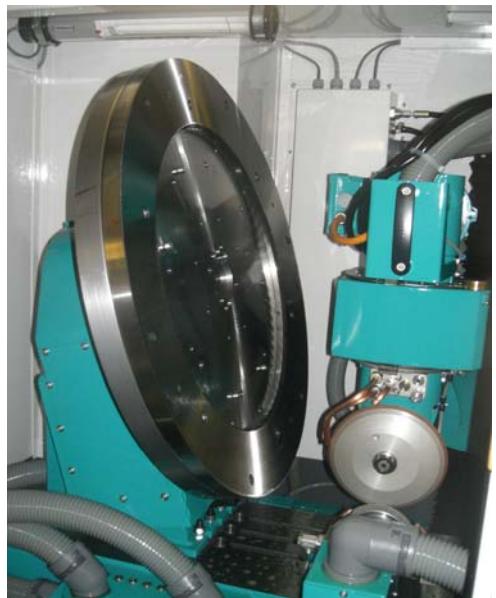


Pulverizing Disc Ø800 Z800

A24-200

Mounted on an inclined dividing table, pulverizing discs of diameter up to 850 mm can be manufactured or resharpened with the ARIES ENP4. In combination with a dressing unit, an optimal conditioning of the grinding wheel is possible. The implemented program for pulverizing discs allows to define partial increments, the concave angle of the disc, the cutting angle, the number of teeth from one dressing cycle to another, etc...



1. Cycletime for Production

| Tool specifications | | | |
|---|-------------|---------|----------|
| Diameter 800 mm, Z 800, tooth length 120 mm | | | |
| Material HSS | | | |
| Operations | Teach Wheel | Flute 1 | Dressing |
| Feed [mm/Min] | 2000 | 650 | 100 |
| Power [kW] | | 3 | 1 |
| Cutting feed [m/s] | | 36 | 12 |
| Used wheels | 15 | 15 | 15 |
| Grinding time [s] | 84 | 35221 | 150 |
| Total cycle time | 590 Min 55 | | |



The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

| | |
|----|---------------|
| 15 | 1V1 Ø200 B126 |
|----|---------------|



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3. Machine and Software Requirements

Machines: 5 axes CNC grinders : ARIES ENP4
 Control: Fanuc PowerMate
 Coolant: Synthetic Oil, pressure 6 bar
 Software: Menuguided ISO-programming with macroexecuter

responsible engineer: MGV, 31.3.09

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